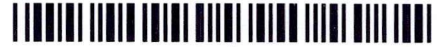




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4463-041
Job Sheet 195835



Part No: D4463-041

Job Qty: 4 pcs

Part Name: Tank Top Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/31/19

Job Tracking No:

Due Date: 6/17/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEETS 1,2 IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC IPP REV:B 12.04.25 AS PER
DWG REV.B DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		6/17/19	0.01	1.58	Waterjet - Flow		06/19/06/06
110	QC 2	4 pcs		6/17/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		06/19/06/06
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Plex 5/31/19 8:40 AM Dart.lajeunesse.marie

120 QC 8	4 pcs	6/17/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Small Fab - 2 - B4B	4 pcs	6/17/19	0.00 1.50	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
140 QC 5	4 pcs	6/17/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
150 Handfinish - 1-1 Chemical-B4B	4 pcs	6/17/19	0.00 0.64	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	

DAS
40
JUN 06 2019 9-89

DAS
58
JUN 11 2019 9-89

DAS
40
JUN 12 2019 9-89

★ JUN 12 2019

				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160	QC 7	4	6/17/19	0.00 0.00	QC 7 - 10
		pcs			QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
					QC 7 - 24
					QC 7 - 43
170	Small Fab - 3 - B4B	4	6/17/19	0.00 1.50	Small Fab - 1 - B4B
		pcs			Small Fab - 2 - B4B
					Small Fab - 3 - B4B

DAS
JUN 1 2 2019 40
9-89

DAS JUN 1 3 2019

58
9-89

180	QC 5	4 pcs	6/17/19	0.00 0.00	Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
190	Packaging 3-1 - Stock - B4B	4 pcs	6/17/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
200	QC 21 - SA	4 pcs	6/17/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	

DAS
40
9-89

JUN 14 2019

PC WA003

DAS JUN 17 2019
21
9-89

QC 21 - SA - 53

Part Op **110** - (QC2- Inspect parts off machine FAI/FAIB)
 Descriptions: **120** - (QC8- Inspect parts - second check)
140 - (QC5- Inspect part completeness to step on W/O)
150 - (Chemical Conversion Coat per QSI005 4.1)
160 - (QC7-Inspect Chemical Conversion Coat)
180 - (QC5- Inspect part completeness to step on W/O)
190 - (Identify as per dwg & Stock Location:_____)
200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	15.4560 sf (3.864 ea)	100-Waterjet - Flow - 1	3152151
MS20426AD3-4	Rivet	192 Ea (48 ea)	170-Small Fab - 3 - B4B	4m136444-2
NAS1473R3	Anchor Nut	96 Ea (24 ea)	170-Small Fab - 3 - B4B	S119245

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.063	15	364	0
170-Small Fab - 3 - B4B	MS20426AD3-4	192	2,445	0
	NAS1473R3	96	66	0

Part Specifications

Specifications could not be found.

Plex 5/31/19 8:40 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	195835
Description: Tank Top		Part Number:	D4463-1
Inspection Dwg: D4463	Rev: D	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	Ø.097	1		V=Ø.02	
Ø0.206	+0.005/-0.001	Ø.208	1		V=Ø.02	
Ø1.00	+0.012/-0.001	Ø.999	1		V=Ø.02	
1.15	+/-0.030	1.15	1		Temp	
1.85	+/-0.030	1.85	1			
2.20	+/-0.030	2.20	1			
2.30	+/-0.030	2.30	1			
5.29	+/-0.030	5.29	1			
8.30	+/-0.030	8.30	1			
8.93	+/-0.030	8.93	1			
8.98	+/-0.030	8.98	1			
9.31	+/-0.030	9.31	1			
10.42	+/-0.030	10.42	1			
11.26	+/-0.030	11.26	1			
1.61	+/-0.030	1.61	1			
1.68	+/-0.030	1.68	1			
1.82	+/-0.030	1.82	1			
3.41	+/-0.030	3.41	1			
3.79	+/-0.030	3.79	1			
6.43	+/-0.030	6.43	1			
7.36	+/-0.030	7.36	1			
7.80	+/-0.030	7.80	1			
10.75	+/-0.030	10.75	1			
11.38	+/-0.030	11.38	1			
11.80	+/-0.030	11.80	1			
13.27	+/-0.030	13.27	1			
1.15	+/-0.030	1.15	1			
3.00	+/-0.030	3.00	1			
3.26	+/-0.030	3.26	1			
7.00	+/-0.030	7.00	1			
10.74	+/-0.030	10.74	1			
11.00	+/-0.030	11.00	1			
11.63	+/-0.030	11.63	1			
15.29	+/-0.030	15.29	1			
15.48	+/-0.030	15.48	1			
19.48	+/-0.030	19.48	1			
23.48	+/-0.030	23.48	1			
23.67	+/-0.030	23.67	1			
24.11	+/-0.030	24.11	1			
27.46	+/-0.030	27.46	1			

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	12.02.01	New Issue P/O D4463-041	KJ	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	
C	14.10.08	Dwg Rev updated	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S188107



Part: D4463-041

Job No: 195835

Serial No/Batch: S188107

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA

TEL.: 1 813 632-5200

Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/06/19